

Date: Tuesday, 10/02/2009 1:08:58 PM  
 User: Melanie Fauteux

Split

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BASE ASS'Y
Job Number	: 45678 -2		
Estimate Number	: 13043		
P.O. Number	:	Part Number	: D3651041
This Issue	: 10/02/2009 S.O. No. :	Drawing Number	: D3651 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/	Drawing Revision	: B
Previous Run	: 42040 Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 17/02/2009
Checked & Approved By	: <u>mf 09-02-10</u>	Qty:	2 4 Um: Each
Comment	: Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D3651043	Flange Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 FLANGE ASSEMBLY B 42114

FF 09/02/25 (4)

3.0	D36511	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 GASKET B 44674

FF 09/02/25 (4)

4.0	D36519	Inside Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 DOUBLER B 45451

FF 09/02/25 (4)

5.0	D365111	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 GASKET B 45452

FF 09/02/25 (4)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASSY

Job Number: 45678

Part Number: D3651041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D365113	Outside Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

DOUBLER

B 45453

FF 09/02/25

(4)

7.0	CR3523402	RIVET
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Comment: Qty.: 58.0000 Each(s)/Unit Total: 232.0000 Each(s)

RIVET

m 110914

FF 09/02/25

(4)

8.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: 1-Assemble as per dwg D3651

2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651

Batch: m 110624

3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651

Batch: M 105623

FF 09-03-17

(2)

FF 09/02/26

(4)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

~~Sorter~~ 09/03/18

(42)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: \_\_\_\_\_

w/o # 4544A

FF 09-03-18

(2)

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

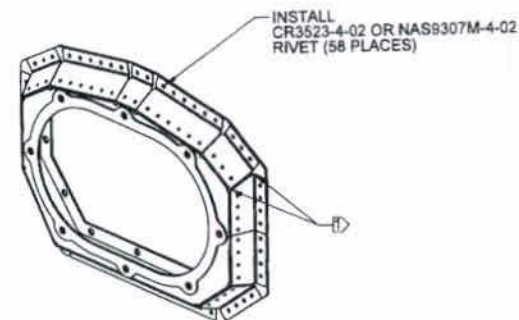
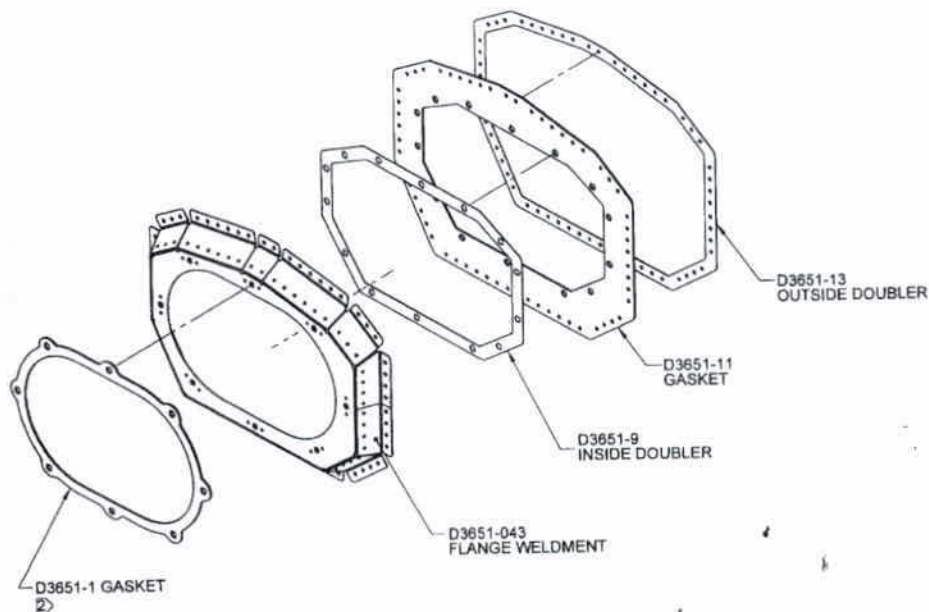
09/03/19

Job Completion



MF  
09-03-18





#### PART LIST

QTY	PART NUMBER	DESCRIPTION
-041		
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

#### D3651-041 AFT BASE ASSEMBLY

#### D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98, REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
DATE	08.01.07	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD.          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR FOR REPRODUCTION IN ANY FORM WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	